5/42

DART AEROSPACE LTD	Work Order:	24400
Description: Bushing	**Part Number:**	D2617-3
Dwg: D2617 Rev. ~~D~~ D2	**Qty:**	~~50~~ 51
05.10.03 05.10.03		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		05.10.04	50
2	MC	Machine as per Folio FA437 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) **Identify as D2617-3** Batch: M18730		05/10/26	51
3	QC2	Inspect parts as they come off the CNC machine		05/10/26	51
4	QC8	Second check	J.L	05/10/26	51
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	DL	05/10/31	51
6	FP	Acid Etch and Alodine as per QSI 005 4.1	SAD	05/11/19	51
7	QC5	Inspect work to Step ~~6~~ 3	CL	05/11/24	51
8	ST	Identify and Stock Loc: 49		05/11/24	51
9	AC	Cost / part: _____	SAC	05-11-25	51
10	DC	Close W/O Inspect Level 21		05/11/25	51

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	04.07.14	Reformat; added step 5	KJ/JLM	

RELEASED
04.07.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 05/11/25

NOTE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

DART AEROSPACE LTD	Work Order:	24400
Description: Bushing	Part Number:	D2617-3
Inspection Dwg: D2617 **Rev:** ~~D~~ D2		Page 1 of 1

KJ 05.10.03 CP 05.10.03

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.857	+0.000/-0.010	0.852	—			
0.369	+0.004/-0.005	0.369	—			

Measured by:	JML
Date:	05/10/26

Audited by:	EP
Date:	05/10/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	JLM

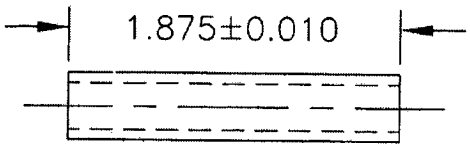
RELEASED
04.08.11

DART

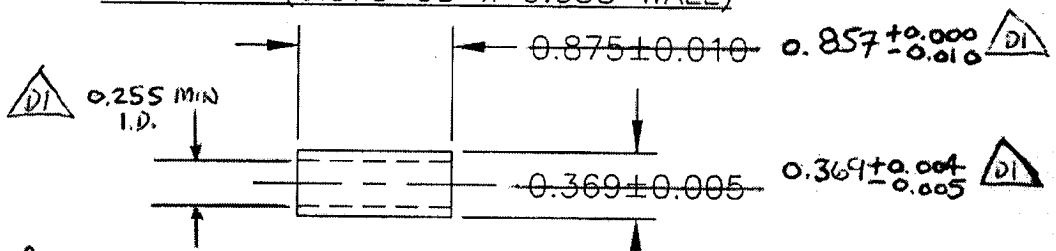
DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING	SCALE 1:1

D2	04.09.10 GP	ADD D2617-7	
A		96.10.08	NEW ISSUE
B		97.05.08	.875 WAS 1.125
C		97.06.04	0.369 DIA WAS 0.375
D		01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
D1	GP	04.07.12	CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)

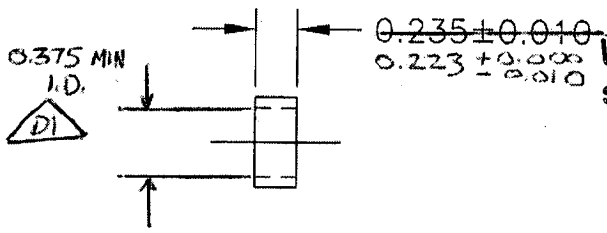


D2617-3 (0.375 OD x 0.058 WALL)



D2617-7 → SAME AS D2617-3 EXCEPT MADE FROM DELRIN (MDELRIN-R)

D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

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SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 24400

NOTES:

1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
   OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 03, 2005
11:23 am

Work Order No	: 0024400		
Project Name	: D2617-3	Department Code:	
Project For	: WK542	Burden Flags	: NNNNNNN
Work Order Type	: Main	WO Status	: Open
Main WO Number	:	Invoice State	: Not Invoiced
House Part Number	: D2617-3	Invoice Date	:
Description	: Bushing	Invoice Number	:
Manufactured	: Yes	Invoice Amount	: 0.00
Amount Req'd	: 50		
Amount Done	: 0	Order Entry No	:
Start Date	: 10-03-05	OE Value	: 0.00
Est Finish Date	: 10-20-05		
Act Finish Date	:	Est Mark Up	: 0.000%
Drawings Reqd	: No	Actual Mark Up	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00